

**Claims:**

What is claimed is:

1. A method of making a roll of adhesive tape, comprising the steps of:
  - a) providing a length of tape having a leading end, a trailing end, a first side, and a second side opposite the first side, wherein the second side of the tape is at least partially covered with pressure sensitive adhesive;
  - b) providing a tab having first and second opposite ends, a length between the first and second ends, a first side, and a second side, wherein at least a portion of the second side of the tab is covered with pressure sensitive adhesive;
  - c) advancing the length of tape along a tape path;
  - d) positioning the leading tape end about a central tape roll axis and circumferentially winding the length of tape about the axis until a penultimate tape layer is wound, wherein the penultimate tape layer has a circumference;
  - e) applying the adhesive-covered portion of the second side of the tab to the first side of the tape so that the second end of the tab is spaced from the trailing end of the tape length by a predetermined distance, wherein the predetermined distance is at least as long as the circumference of the penultimate layer of the tape roll and no longer than a total distance of the circumference of the penultimate layer and the length of the tab; and
  - f) circumferentially winding a final layer of the tape length around the penultimate tape layer so that the trailing end of the tape overlays the tab between the first and second ends of the tab.
2. The method of claim 1, wherein the provision of a tab further includes providing the second side of the tab with an adhesive portion and a non-adhesive portion.

3. The method of claim 2, wherein the provision of a tab further includes covering at least a portion of the adhesive on the second side of the tab with a deadening layer to provide the non-adhesive portion.
- 5 4. The method of claim 3, wherein the provision of a tab further includes laminating a web material to at least a portion of the adhesive on the second side of the tab to provide the non-adhesive portion.
- 10 5. The method of claim 2, wherein provision of a tab further includes folding at least a portion of the adhesive portion of the second side of the tab toward the second side of the tab so that the folded portion adheres to at least a portion of the second side of the tab, thereby providing the non-adhesive tab portion.
- 15 6. The method of claim 1, wherein the provision of adhesive tape and provision of a tab further comprise providing the second side of the tab with an adhesive having the same adhesive strength as the adhesive on the second side of the tape length.
- 20 7. The method of claim 1, wherein the provision of adhesive tape and provision of a tab further comprise providing the second side of the tab with an adhesive having a greater adhesive strength than the adhesive on the second side of the tape length.
- 25 8. The method of claim 1, wherein the provision of adhesive tape and provision of a tab further comprise providing the second side of the tab with an adhesive having a lower adhesive strength than the adhesive on the second side of the tape length.
- 30 9. The method of claim 8, wherein the adhesive on the second side of the tab is a repositionable pressure sensitive adhesive.

10. The method of claim 1, wherein the provision of a tab further includes providing a tab having the entire second side coated with pressure sensitive adhesive.
- 5 11. The method of claim 1, further comprising the step of providing a tape core defining the central tape roll axis, wherein the tape length is circumferentially wound about the core.
- 10 12. The method of claim 1, wherein the provision of a tape length further comprises providing a tape length having a width, wherein the provision of a tab further includes providing a tab having a width, and wherein the width of the tape length is approximately equal to the tab width.
- 15 13. A method of making a roll of adhesive tape, comprising the steps of:
  - a) providing a core;
  - b) providing a web of adhesive tape material having first and second sides, wherein the second side of the tape material is at least partially covered with adhesive;
  - 20 c) circumferentially winding the web of adhesive tape material around the core with the second side of the tape facing the core until a piece of the tape material having a length that is at least as long as one circumference of the tape roll extends from the tape roll,
  - d) providing a tab having first and second opposite sides, wherein at least a portion of the second side is covered with adhesive;
  - 25 e) applying the adhesive portion of the second side of the tab to the first side of the tape material;
  - f) cutting the tape material from the web of tape material to define a trailing tape end; and

- g) circumferentially winding the piece of the tape material extending from the tape roll until the tape material adjacent the trailing tape end overlays at least a portion of the tab.

5    14.    A method of placing a tab near the end of a roll of pressure sensitive adhesive tape to facilitate an initial unwinding of adhesive tape from the roll, comprising the steps of:

- 10            a)    providing a roll of adhesive tape having first and second opposite surfaces, a trailing tape end, and a circumference, wherein at least a portion of the second surface is at covered with pressure sensitive adhesive, and wherein a length of the tape that is at least as long as one circumference of the roll extends beyond the roll;
- 15            b)    applying a tab to the first surface of the tape at a distance from the trailing tape end that is approximately equal to one circumference of the tape roll, wherein the tab comprises a first side and an opposite second side that is at least partially coated with pressure sensitive adhesive, and wherein the adhesive-coated portion of the second tab side is adhered to the first surface of the tape material; and
- 20            c)    winding the extending portion of the tape circumferentially around the tape roll so that at least a portion of the tape adjacent the trailing tape end overlays at least a portion of the tab.

15.    A tape roll comprising:  
          a central tape roll axis;  
25            a length of tape comprising a leading end, a trailing end opposite the leading end, a first side, and a second side opposite the first side, wherein the second side of the tape is at least partially covered with pressure sensitive adhesive, and wherein the tape is circumferentially wound about the axis until a plurality of adjacent tape layers are wound; and

a tab having first and second opposite ends, a first side, and a second side opposite the first side, wherein at least a portion of the second side of the tab is covered with pressure sensitive adhesive;

5 wherein the adhesive portion of the second side of the tab is adhered to the first side of the tape on a penultimate tape layer of the roll so that the trailing end of the tape overlays the tab between the first and second ends of the tab.

16. The tape roll of claim 15, wherein the second side of the tab further comprises an adhesive portion and a non-adhesive portion.

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17. The tape roll of claim 16, wherein the tab further comprises a deadening layer to provide the non-adhesive tab portion.

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18. The tape roll of claim 15, wherein the tab further comprises at least a portion of the adhesive portion of the second side of the tab folded toward and adhered to the second side of the tab to provide the non-adhesive tab portion.